

5/22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23157
<b>Description:</b> Bearpaw Kit (19" x 24")	<b>Part Number:</b>	K10008
<b>Dwg:</b> D2432 Rev. F3	<b>Qty:</b>	20 Kits
<b>Ref:</b> K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																	
1	DC	Issue Traveler <b>Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required</b>	AP	05/05/09	20																																																	
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 WK 20 <i>KA</i> <b>(Bag Bluefiles separately)</b>	DH	05.05.30	20																																																	
3	GA	<b>Cut 2 blanks per (1) K10008 Kit</b> Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMBW10) Batch: <i>M1772L</i> <del>1418</del>	ML	05/06/08	20																																																	
4	MV	Inspect material for defects or damage prior to machining	ML	05/06/08	20																																																	
5	MV	Machine as per Folio D2432 and Dwg D2432 <b>Identify as D2432F</b>	SD/ML	05/06/08	20																																																	
6	QC2	Inspect parts as they come off the CNC machine	ML	05/06/08	20																																																	
7	MV	Deburr	SD	05.06.16	20																																																	
8	QC8 & 5	Second inspection	FC	05.06.16	20																																																	
9	KP	<b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td><i>B21823</i></td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td><i>B23174</i></td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td><i>B23157</i></td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td><i>B22503</i></td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td><i>B22504</i></td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td><i>B22505</i></td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td><i>M16067</i></td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td><i>M14526 / M15422</i></td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td><i>M16941</i></td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td><i>M15924</i></td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	<i>B21823</i>	12	D2274	Radius Block	<i>B23174</i>	2	D2432F	24" Bearpaw	<i>B23157</i>	6	D2438	Clamp	<i>B22503</i>	12	D2529	Washer	<i>B22504</i>	6	D2732-050	Rubber Cushion	<i>B22505</i>	12	AN4-15A	Bolt	<i>M16067</i>	12	AN4-17A	Bolt	<i>M14526 / M15422</i>	24	AN960JD416	Washer	<i>M16941</i>	12	MS21042L4	Nut (or -4)	<i>M15924</i>	1	Paperwork package from Step 2			B21872	DL	05/06/20	20
Qty	Part Number	Description	Batch																																																			
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1	Paperwork package from Step 2																																																					
10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/06/20	20																																																	
11	PK	Identify and pack for shipping as per PPP K10008 <i>rev = E</i>	DL	05/06/20	20																																																	
12	AC	Cost / part <i>207.92</i>	AP	05/06/22	20																																																	
13	DC	Close W/O <i>222.62</i> Inspect Level 21	KA	05.06.27	20																																																	

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	#

RELEASED  
04.02.20

05/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23151
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.070 X 45°	✓		Vern	
B	5.500	+/-0.030	5.505	✓		Vern	
C	0.200	+/-0.030	0.198	✓		Vern	
D	0.25 x 45°	+/-0.030	0.25 X 45°	✓		Vern	
E	R0.250	+/-0.030	R0.250	✓		R-G	
F	0.250	+/-0.010	0.245	✓		Vern	
G	0.625	+/-0.030	0.620	✓		Vern	
H	0.375	+/-0.010	0.380	✓		Micr	
I	0.950	+0.030/0.010	0.945	✓		Vern	
J	19.000	+/-0.030	19.000	✓		M-Tape	
K	3.14	+/-0.030	3.136	✓		Vern	
L	3.28	+/-0.030	3.310	✓		Vern	
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
N	Ø0.93	+/-0.030	Ø0.929	✓		Vern	
O	0.30	+0.030/-0.000	0.302	✓		Vern	
P	23.750	+/-0.030	23.750	✓		M-Tape	
Q	7.375	+/-0.030	7.375	✓		Vern M-Tape	
R	4.250	+/-0.010	4.250	✓		Vern	
S	2.000	+/-0.030	2.000	✓		M-Tape	
T	9.000	+/-0.010	9.000	✓		M-Tape	
U	9.000	+/-0.010	9.000	✓		M-Tape	
V	0.375	+/-0.010	0.385	✓		Vern	

Measured by: <i>gme</i>	Audited by: <i>EP</i>	Prototype Approval:	N/A
Date: 05/04/08	Date: 05/06/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

RELEASED

04.01.15

Supp. COPY

RETURN TO  
ENGINEERING

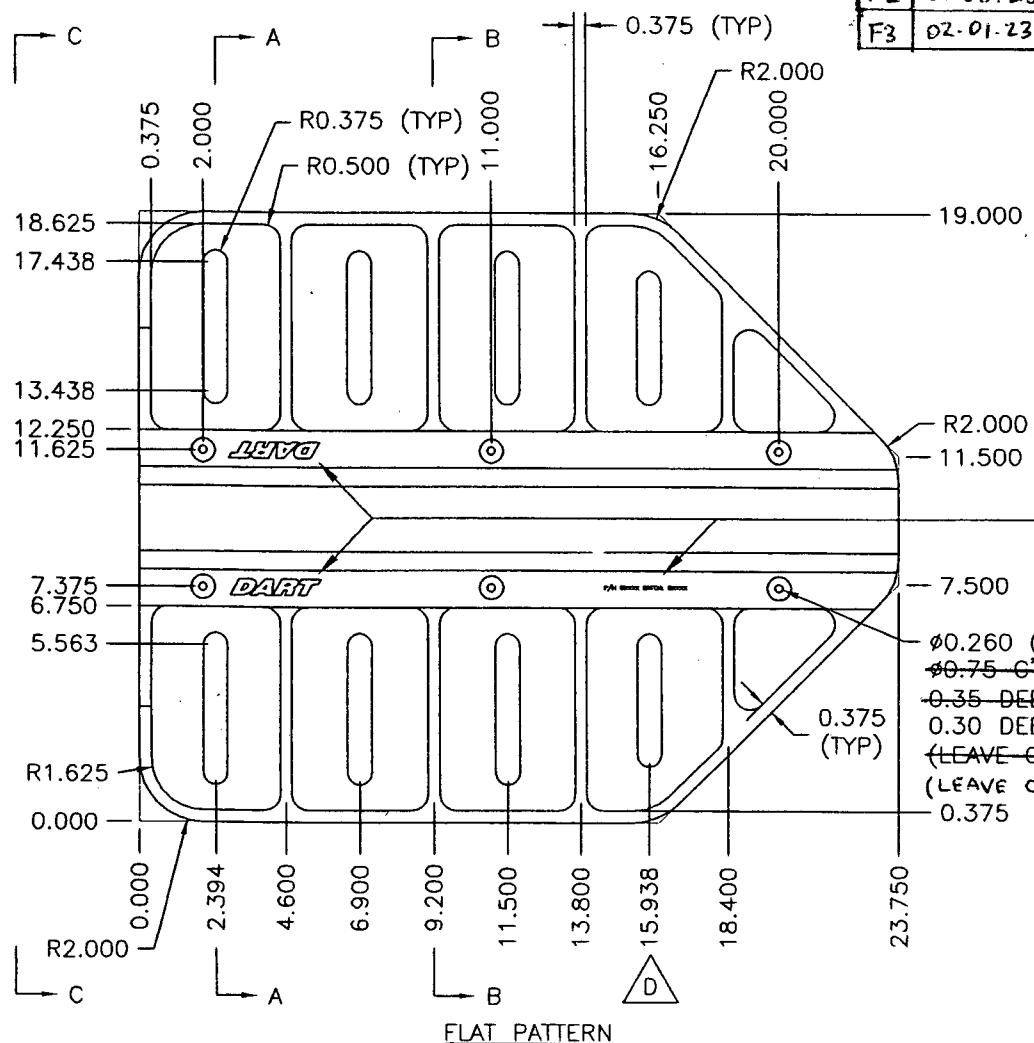
UNCLASSIFIED  
SUSCEPTIBLE TO  
DECLASSIFICATION  
WITHOUT NOTICE



WORK ORDER

NO 2357  
RELEASED  
43.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02-01-23	CLARIFY BORE DIMS <del>RF</del>

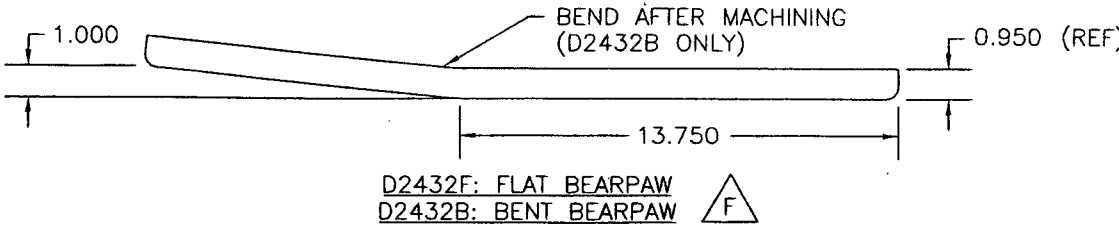


ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	JS	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F2  
F1  
F  
F1

EFFECTIVE	DEOS
9143	

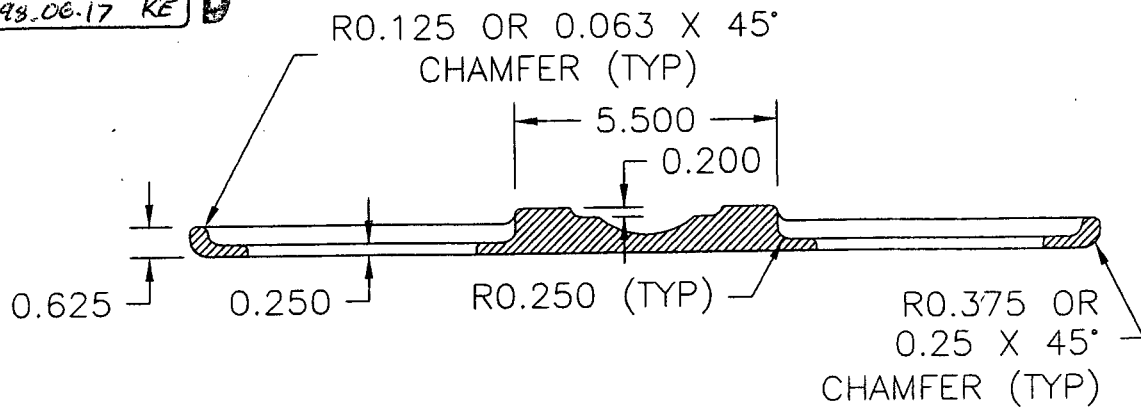


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

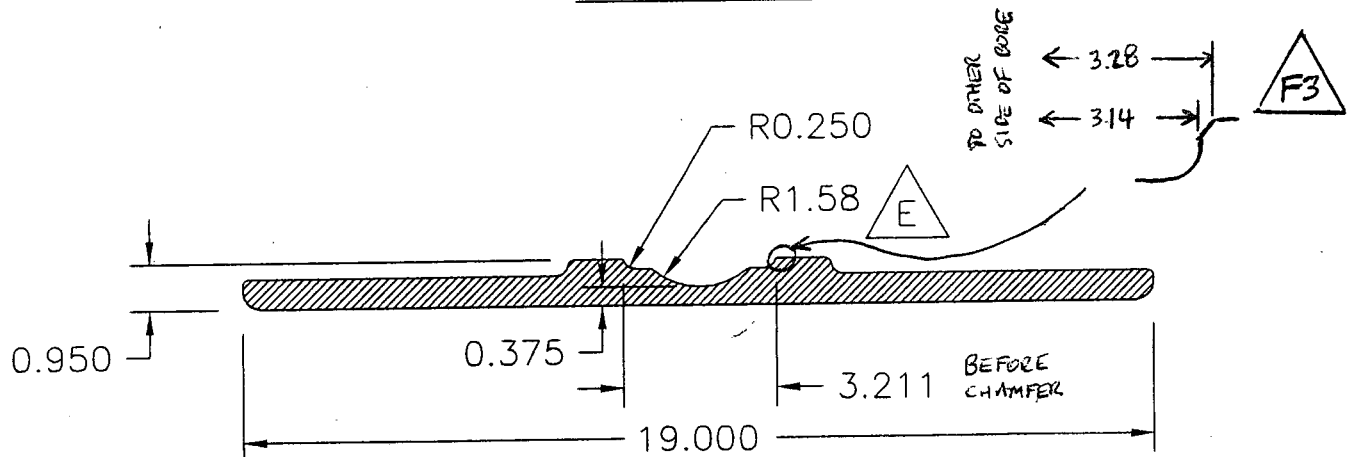


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



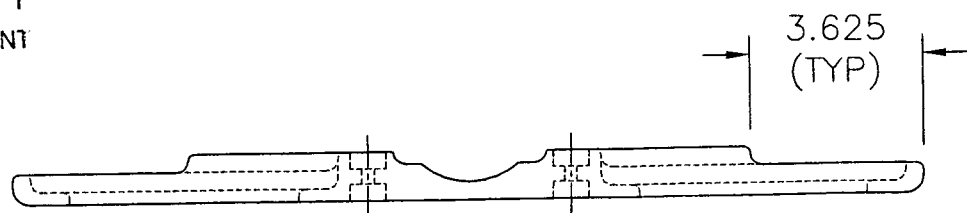
SECTION A-A



SECTION B-B

SHOP COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 23151



SECTION C-C

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 06, 2005  
09:55 am

Work Order No : 0023157

Project Name : K10008

Project For : WK522

Work Order Type : Main

Main WO Number :

House Part Number : \*K10008

Description : Bearpaw kit 19" x 24"

Manufactured : Yes

Amount Req'd : 20

Amount Done : 0

Start Date : 05-04-05

Est Finish Date : 05-31-05

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000%

Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00